

Date: Wednesday, 23/07/2008 3:06:08 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 40734 - 3

Estimate Number : 13298

P.O. Number :

This Issue : 23/07/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / /

Previous Run : 39036

Written By :

Checked & Approved By :

Comment :

Est Rev:A 08-05-01 new issue DD verified by:EC

Est Rev:B 08-07-22 revB as per dwg DD verified by:EC

Drawing Name : SUPPORTING PLATE

Part Number : D37811

Drawing Number : D3781 PRELIM

Project Number : N/A

Drawing Revision : PRELIM

Material :

Due Date : 30/07/2008

10 Um: Each

PROTOTYPEPLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

FOR ENGINEERING USE ONLY

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S080

6061-T6 .080 Sheet



Comment: Qty.: 0.2896 sf(s)/Unit Total : 2.8959 sf(s)

6061-T6 .080 Sheet

batch: 107460 IB 8-7-23

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3781-1

Dwg Rev: PRE-L

Prog Rev: PRE-L

*****grain direction along 3.61" *****

2- Deburr if necessary

IB 8-7-24

(14)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-7-24

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 00/07/24 (14)

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3781

IB 8/11/12 (1)

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-counter sink holes as per dwg D3781

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**

08.11.12

①

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Not REQ'D
08.11.12

10.0 MS20426AD34 RIVET



Comment: Qty.: 10.0000 Each(s)/Unit Total: 100.0000 Each(s)

RIVET

batch: M105978

08.11.12

①

11.0 MS21075L3 Nutplate



Comment: Qty.: 5.0000 Each(s)/Unit Total: 50.0000 Each(s)

Nutplate

batch: 1/09068

08.11.12

①

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1- assemble nut plate as per dwg D3781

08.11.12

①

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL****ENGINEERING
APPROVAL****PROTOTYPE**

08.11.13 ①

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

08.11.13

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORTING PLATE

Job Number: 40734

Part Number: D37811

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

~~Lead/Check 1/2 send to Andy~~

N/A

608-11-13

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/11/13

4 08-11-13

Job Completion

~~POSITIVE RECALL~~~~EFFECTIVE 08-11-13 AUTH 4~~~~POSITIVE RECALL~~~~RELEASED DATE~~~~EFF~~~~REL~~

FOR FIT & FUNCTION PURPOSES
ONLY. SHIP TO DAVID SHEPHERD.
NOT FOR STOCK.

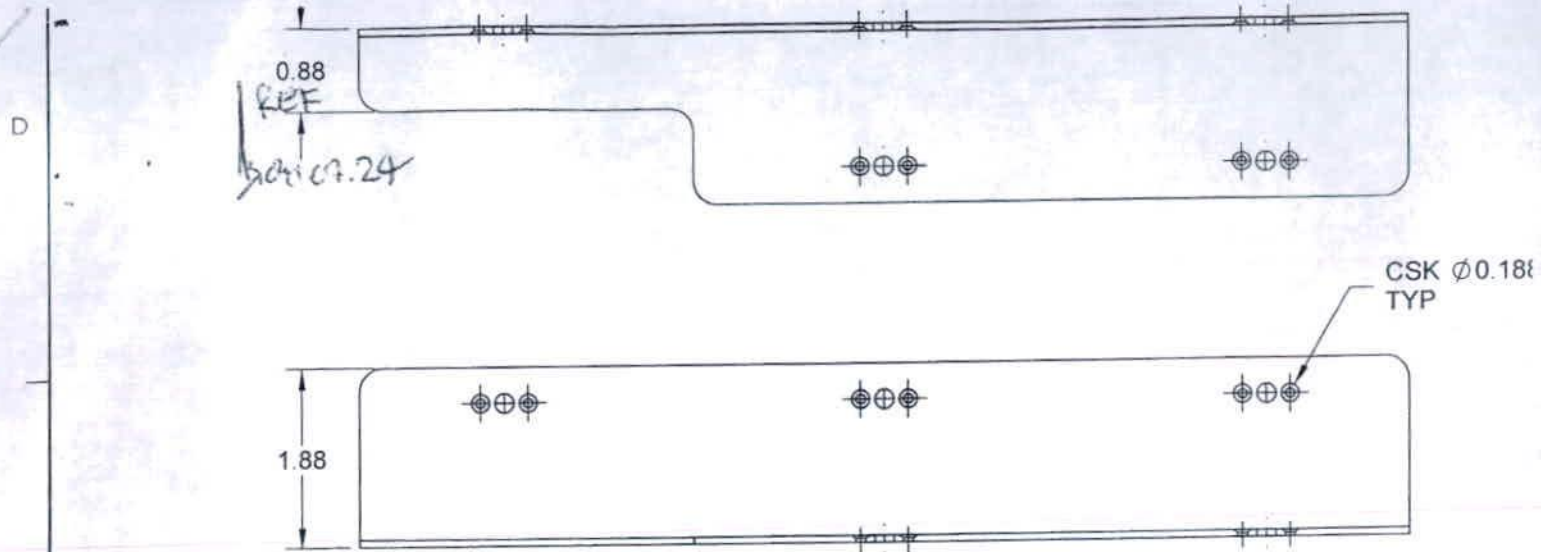
PROTOTYPEPLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

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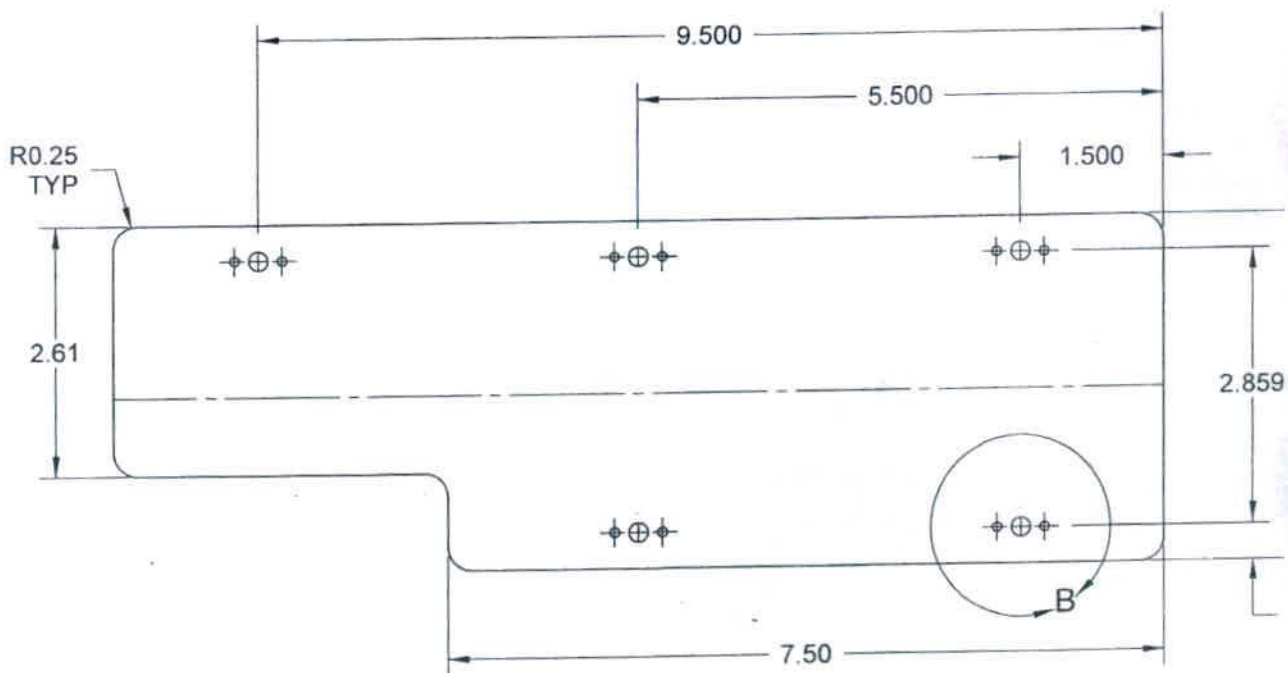
FOR ENGINEERING USE ONLY

THE KING JEEHUNG (25.04.17)

THE KING JEEHUNG (25.04.17)



D3781-1 SUPPORTING PLATE
MAKE FROM D3781-1F

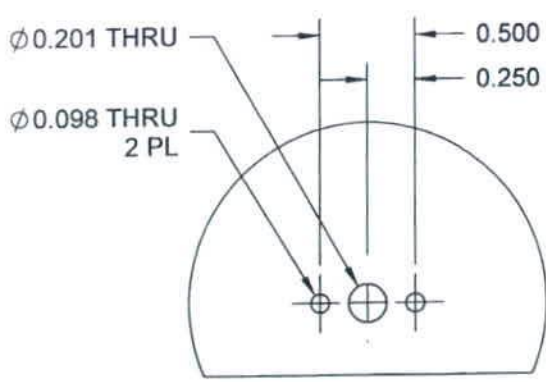
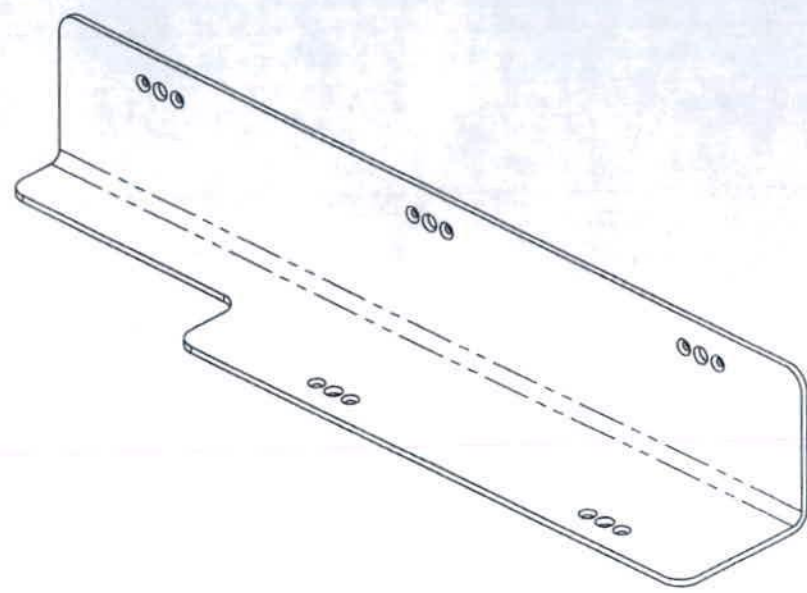


D3781-1F FLAT PATTERN

D3781-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

WFO
40734



PROTOTYPE
 PLEASE RETURN ALL ISSUED
 DATA TO ENGINEERING
 2008.11.13
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DETAIL B
 SCALE 2X, 5 PL

PRELIMINARY ISSUE
 08.07.16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3781	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
DATE	08.07.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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CONC. TEMPERATURE DATA

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